Work Orde June-12-13 9:15	er ID 102 5:22 AM	2851 D 2 1 9 9		*102	2851*						Page 1
Revision ID:	D2199-23 Strut Details	B 1 0 2 8 R E V E 1	51	Accept	*N900	040	100)* s	etup Star Stop	1 41	S1* S2*
Start Date: Required Date: Reference:	6/11/13 6/11/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:					
Approvals:	Process Plan: MLゴ QC:		Date: 13-06-12	Tooling: _ SPC (Y/N):	Date:			R	un Star Stop	171	R1* R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr									
D2199	Rev	E1									6/2
*100 *100* Brake NC Brake NC		NC BRAKE Memo Punch per I	Dwg D2199 and Spec Contro	0.00 0.00 of Dwg D2638				<u>-</u>			(3 °4)
*110 *110* Small Fab Small Fab		Small Fab Memo Deburr		0.00				4x			<i>SS</i> 3/0.
120 *120 QC Quality Control		QC5- Inspect part comp	leteness to step on W/O	0.00 AS 0.00 Jes Y	3 67 64			44			

DQA:		<u></u>	Date:	<u> </u>										
QA Closed:			Date:			WORK ORDER NON	-CC	ONFO	RMANCE / UPDATE	W	ork Order up	ndate only	AEROS	PACE
arroloscu.	-	 	- Dute.			DICROCITION			A C A INIC		•			
Work Orde	er:					DISPOSITION			AGAINS	ו טנ	PARTMENT	PRUCESS		
				·		Rework			Skid-tube Crosstube	2. 97	Water Jet	Engineering	g 📗	
Part N	۱o. <u>_</u>					Scrap			Machining Small Fal	li Fab Prod. Eng. Coor. Qual				
						Use-as-is		Therr	~ }	Finishing Rec/Store/Packaging Ot				
NCR N	No					Suspected Unapproved]		Large Fab Composite	Composite Supplier				
Root	Des				Desc	ription of work order update		nitial	Action		Sign &			
Cause		Date Step Qty				or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspe	ctor
Design						,								
Doc/Data	Ц													
Equip/Tooling												:		
Handling/Pre	Ш					•								
Material	Ш													
Operator	Ц													
Offset/Setup	Н													
Process	Н													
Supplier	Щ													
Training	Н													
Transport	Н													
Unapproved		-	l		<u> </u>			HIT CA	l Tegory		1			
Landi	na G	035				General	FA	OLI CA	TEGURT					
LOTIO		Bending				Bend	Г] Folio/F	Program		Outside Dim	ensions F	Pressure/Forc	ad
			ot Concer	ntric	<u> </u>	BOM/Route	\vdash	Grain	Toblam	-	Over/Under	<u> </u>	Set-up	cu
	Centre Not Concentric Cracks					Broken/Damage/Defect	\vdash	Hardwa	are		Part Incorred	⊢ -	Temperature/	Cure
	Crimp/Kink/Ripple/Wave					Burrs	\vdash	-	ion Incomplete/Unqualified	\vdash	Part Lost/Mi	⊢	Weld	
	Cuffs					Contamination		1	tions Incomplete/Unclear		Part Moved	·	Wrong Stock F	Pulled
	Crushing					Countersink		4	gned/off center		Positioned V			
	-	Heat Trea	at			Cut Too Short		Mislabe			Power Loss/		Other	
Inspection Strip in Tube						Drawing		Misrea			· ·	- L .		
	Marks/Chatter					Drill Holes		Off-set						
		Turning S	equence			Finish		Out of	Calibration					
	Π,	Wave/Tw	ist in Tub	10		Fit/Function		Out of	Seguence					

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Work Ord June-12-13 9:1		2851		Page 2						
Item ID: Revision ID: Item Name:	D2199-23 Strut Details			Accept	*N900040	100*	Setup	Start Stop	*NS1* *NS2*	
Start Date: Required Date Reference:	6/11/13 e: 6/11/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item ID: Customer:					
Approvals:		an:			Date:		Run	Start Stop	*NR1* *NR2*	
Sequence ID/ Work Center 130 *130* Powdercoat Powder Coating M\ 2 140 *140* QC		Operation Description White Gloss(Ref:4.3.5.2) Memo START TIM U)) [QC3- Inspect Part Finish Memo	IE: FINISH TIME:	Set Up/ Run Hours 0.00 0.00 OVEN TEMPERATUR 0.00 0.00	Tool ID Tool #	Code Qty	Qt	y 1	Reject Insp. Number Stamp	1
Quality Control 150 *150* Packaging		Identify as per dwg & St	ock Location: <u>5726</u>	0.00			· ((3-07-05	-8

Packaging

DQA:			Date:													
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UI		Vork Order uj	odate only	AEROSPACE			
<u> </u>						DISPOSITION										
Work Orde	er:					DISPOSITION				AGAINSI D	EPARTMENT	/PROCESS				
	_			·		Rework			Skid-tube	Crosstube		Water Jet	Engineering			
Part N	No					Scrap		.	Machining	Small Fab	mall Fab Prod. Eng. Coor. Qua					
						Use-as-is		Thern	noforming	Finishing	nishing Rec/Store/Packaging Ot					
NCR N	No					Suspected Unapproved		1	Large Fab	Composite	osite Supplier Supplier					
Root	Des				Desci	ription of work order update		nitial	Act	ion	Sign &					
Cause		Date Step Qty				or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector			
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Equip/Tooling												,				
Handling/Pre																
Material							l					}				
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Offset/Setup	Ш															
Process	Ш						1									
Supplier	Ш						1									
Training	Ш															
Transport	Ш										ŀ					
Unapproved						₹ 										
							FA	ULT CA	regory							
Landi	ng G	ear				General				_	_	_	_			
	-	Bending			<u> </u>	Bend		1	Program		Outside Dim	⊢	Pressure/Forced			
	$\bigsqcup_{}^{'}$	Centre N	ot Concer	ntric	<u> </u>	BOM/Route	<u></u>	Grain			Over/Under	tolerance	Set-up			
	\square	Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorre	ct	Temperature/Cure			
	Crimp/Kink/Ripple/Wave					Burrs	<u> </u>	Inspect	ion Incomplete/Ur	nqualified	Part Lost/M	issing	Weld			
	Cuffs					Contamination		4	tions Incomplete/U	Jnclear	Part Moved		Wrong Stock Pulled			
1	-	Crushing				Countersink		1 '	ned/off center	L	Positioned \	_	_			
Heat Treat						Cut Too Short		Mislabe		L	Power Loss/	'Surge	Other			
	Inspection Strip in Tube					Drawing		Misrea								
	Ш	Marks/Cl	natter			Drill Holes		Off-set								
	-	_	equence			Finish		Out of	Calibration							
		Wave/Tw	vist in Tub	ne .		Fit/Function	1	Out of	Sequence							

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Work Ord June-12-13 9:1		2851			Page 3							
Item ID: Revision ID: Item Name:	D2199-23 Strut Details			Accept	*N900	040	100	*	Setup	Start Stop	ı Vı	S1* S2*
Start Date: Required Date Reference:	6/11/13 e: 6/11/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item ID: Customer:							
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center	ID	Operation Description QC21- Final Inspection	- Work Order Release	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Re Qt	•	Reject Number	Insp. Stamp
160		Memo		0.00						12/	1/5	7

Quality Control

13/7/5 48) NUF (39-5

DQA:															
QA Closed:		Date:			WORK ORDER NON	-C(ONFO	RMANCE / U		Mark Or	dorum	adata only		AEROSPACE	
QA Closeu.		Date.							Work Order update only						
Work Orde	er:				DISPOSITION				DEPART	EPARTMENT/PROCESS					
					Rework	1	Skid-tube Crosstube					Water Jet		Engineering	
Part N	No Scrap Machining Small Fab Prod. Eng. Coor.							П	Quality						
		Use-as-is Thermoforming Finishing Rec/Store/Packaging								Other					
NCR N	lo				Suspected Unapproved]		Large Fab	ab Composite Supplier						
Root De					ription of work order update		Initial	Act	ion	Sig	Sign &				
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	ription		ate	Verificatio	n	QC Inspector	
Design													\Box	· · · · · · · · · · · · · · · · · · ·	
Doc/Data										l					
Equip/Tooling													- 1		
Handling/Pre															
Material										İ					
Operator															
Offset/Setup															
Process													Ì		
Supplier															
Training															
Transport															
Unapproved		<u> </u>													
						FA	ULT CAT	regory							
Landir	ng Gear				General		,		-				_		
	Bending			<u> </u>	Bend		Folio/P	rogram	<u> </u>	Outsi	de Dim	ensions	Ш	Pressure/Forced	
	Centre N	ot Concei	ntric		BOM/Route		Grain			Over/	'Under	tolerance		Set-up	
	Cracks			<u> </u>	Broken/Damage/Defect	$ldsymbol{ld}}}}}}$	Hardwa	re	1	Part I	ncorre	ct	Ш	Temperature/Cure	
1		nk/Ripple	:/Wave		Burrs		Inspecti	ion Incomplete/Ur	nqualified	Part L	.ost/Mi	issing	Ш	Weld	
	Cuffs				Contamination		4	ions Incomplete/U	Jnclear	Part N	Noved			Wrong Stock Pulled	
Crushing					Countersink		1 1	ned/off center	Ļ	_	oned V	•	_		
Heat Treat					Cut Too Short		Mislabe	eled		Powe	r Loss/	Surge	\Box	Other	
Inspection Strip in Tube					Drawing		Misread								
	Marks/Cl				Drill Holes		Off-set								
		Sequence			Finish		Out of 0	Calibration							
	Wave/Tv	vist in Tub	oe .		Fit/Function	1	Out of 9	Sequence							

Picklist Print

June-12-13 9:15:22 AM

Work Order ID:

102851

Parent Item:

D2199-23

Parent Item Name:

Strut Details

Start Date: 6/11/13

Required Date: 6/11/13

Start Qty: 4.00

Required Qty: 4.00

Comments:	IPP: D02.06.10R	tem polish & add	11111511110/										
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049 304 RD Tube .750 x .049V	N.	Purchased	No			100	f	480.1769	2.2	9.263158	· · · · · · · · ·	SIL	2/27/0
e to				Location		Loc Oty	<u>L</u> c	c Code					
				MAT017		480.1768825							
				1223	12	13.3							
				12246	68	0.0000325			****				
				12470	68	83.93245							
				12500	68	93.9444							
				1255	13	289				2			

Page 1

DQA:			Date:			- ``AART									
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPE		ork Order up	ndate only	AEROSPACE		
QA closed.			Date.				Ĩ				•	•	1		
Work Orde	er:					DISPOSITION				AGAINST DI	PARTMENT	/PROCESS			
	-					Rework			Skid-tube	Crosstube		Water Jet	Engineering		
Part N	۱o					Scrap			Machining	Small Fab	ab Prod. Eng. Coor. Quali				
						Use-as-is	1	Therr	noforming	Finishing					
NCR I	۷o					Suspected Unapproved			Large Fab	Composite	site Supplier Supplier				
Root	not De					ription of work order update		nitial	Actio	n	Sign &				
Cause	1	Date Step Qty			Desci	or non-conformance	1	ief Eng	!		Date	Verification	QC Inspector		
Design				2.7		•	<u> </u>				1 2 3 3				
Doc/Data	П						1								
Equip/Tooling															
Handling/Pre															
Material															
Operator															
Offset/Setup															
Process							İ								
Supplier															
Training													·		
Transport															
Unapproved															
							FAI	ULT CA	TEGORY				ga		
Landi	ng G	ear				General		•					_		
	Ш	Bending			<u> </u>	Bend	<u></u>	Folio/F	Program		Outside Dim	ensions	Pressure/Forced		
	Ц	Centre No	ot Concer	ntric		BOM/Route		Grain		L	Over/Under	tolerance	Set-up		
	Ш	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	ct	Temperature/Cure		
	Crimp/Kink/Ripple/Wave					Burrs		Inspect	ion Incomplete/Unqu	ualified	Part Lost/Mi	ssing	Weld		
	Cuffs					Contamination		4	tions Incomplete/Und	clear	Part Moved	L.	Wrong Stock Pulled		
Crushing						Countersink		1	gned/off center		Positioned V		_		
Heat Treat					Cut Too Short	<u></u>	Mislab	eled		Power Loss/	Surge	Other			
	Inspection Strip in Tube					Drawing		Misrea	d						
	Ш	Marks/Ch	natter		L	Drill Holes		Off-set							
	\blacksquare	Turning S				Finish	L	Out of	Calibration						
	1 1	Wave/Tw	ist in Tub	ne .		Fit/Function Out of Sequence									

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